

Date: Monday, 7/9/2007 3:47:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 33440	
Estimate Number : 12729	
P.O. Number : NIA	Part Number : D353539
This Issue : 7/9/2007 S.O. No. : NIA	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA	Drawing Revision : A/B PH
Previous Run : 32412	Material : NIA
	Due Date : 7/16/2007
Written By :	Qty: 10 Um: Each
Checked & Approved By : <u>07.07.10</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.9986 sf(s)/Unit Total : 9.9855 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M105061 IB 07-07-21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET CHECK FLAT PATTERN REV.

1-Cut as per Dwg D3535

Dwg Rev: BProg Rev: B

2-Deburr if necessary

IB 07-07-2110

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-07-21

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

EN 07/07/23counted
10

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

FF 07-07-23 10FF 07-07-24 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/01/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:47:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33440

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

carls
Er 07/07/24 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104846

BK/mj 07-07-25

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F-2 07/07/25 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-16

m-l 07/07/25

(10X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
SAK/25

Job Completion



Paul

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

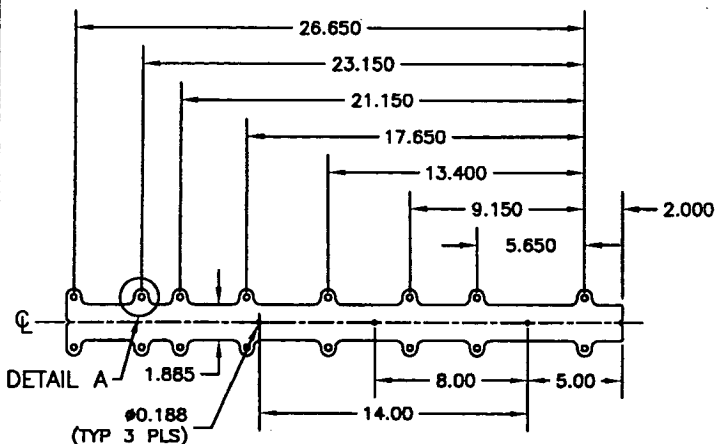
NOTE: Date & initial all entries

DART

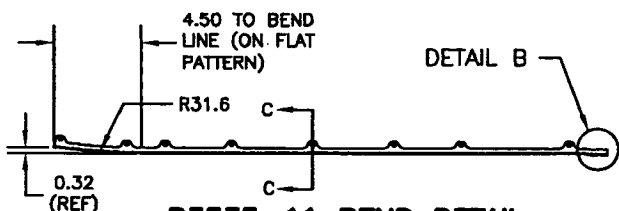
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07.04.24

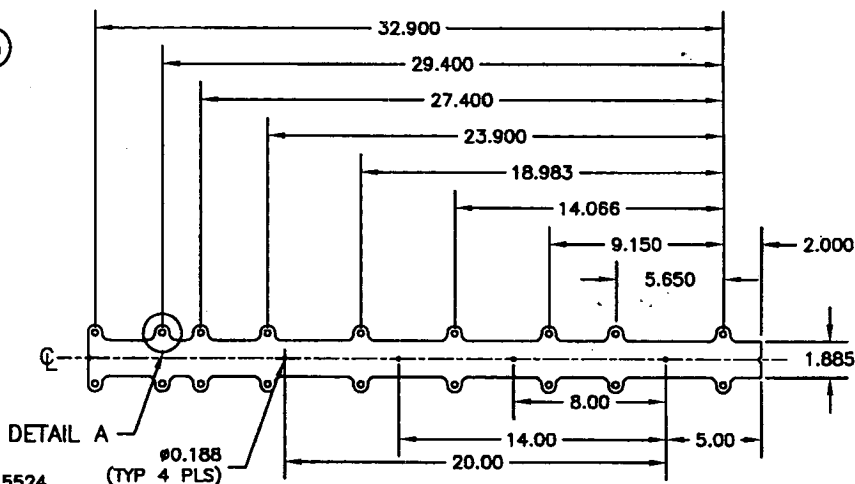
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 1 OF 7
				SCALE 1:10
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



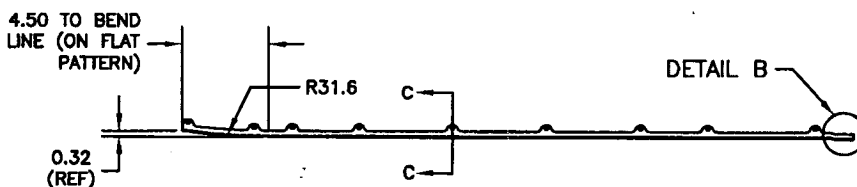
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

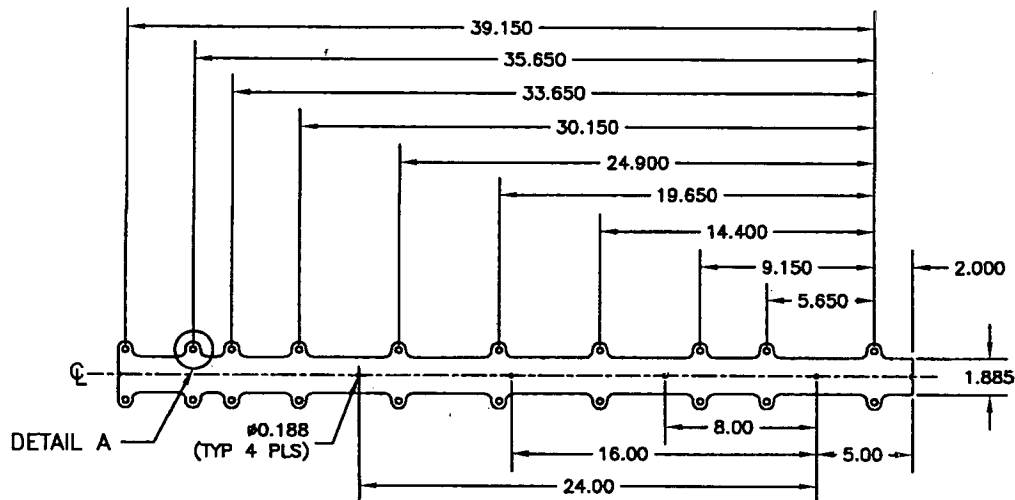
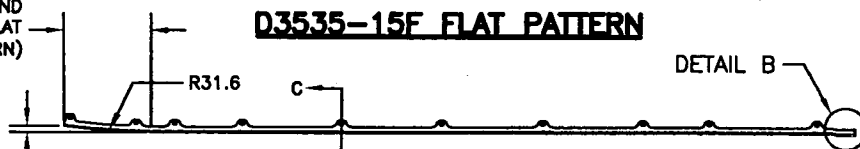
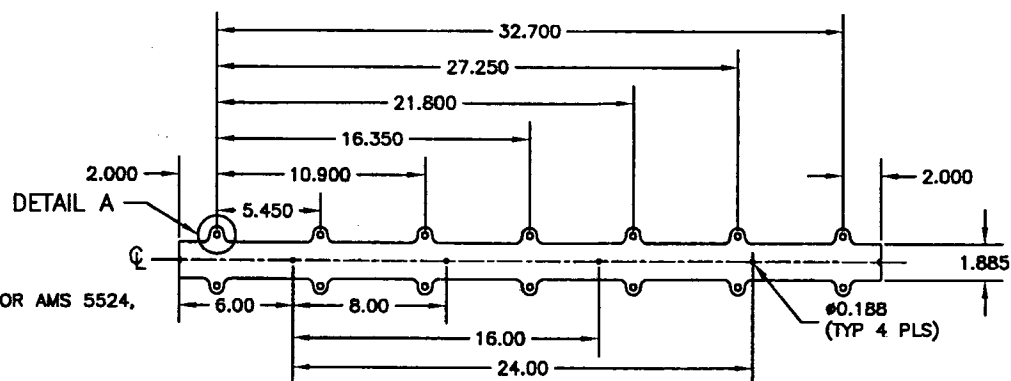
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WORK ORDER
NO 3440

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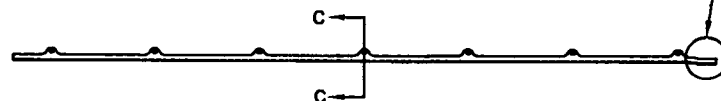
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		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL**

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NOTES

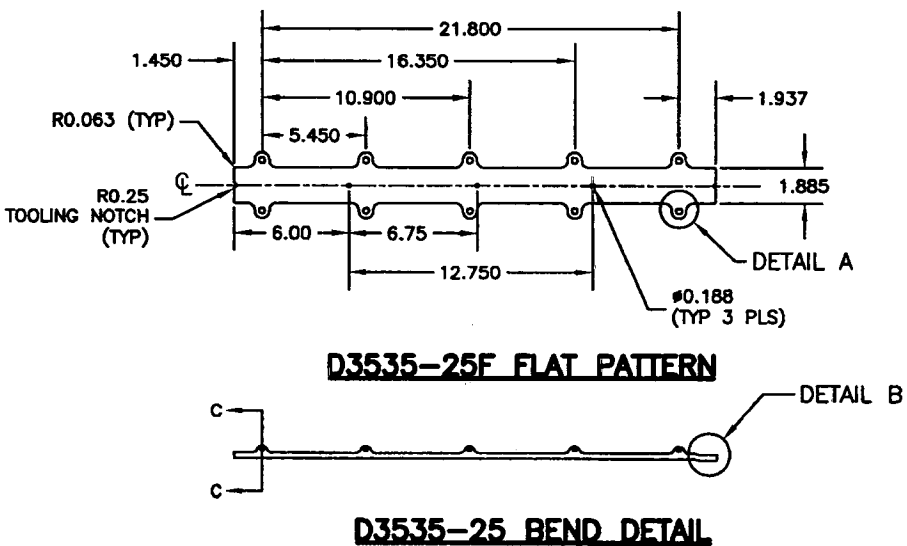
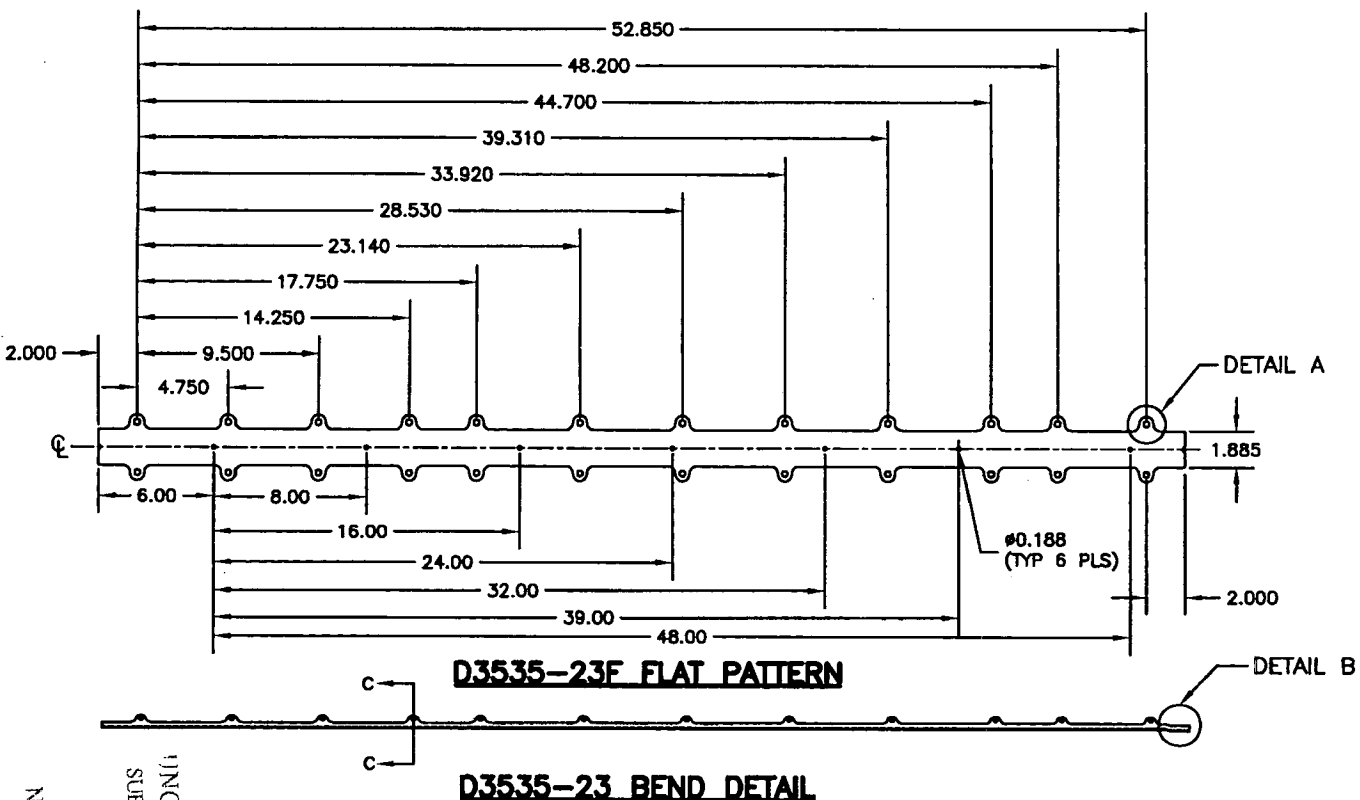
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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#	#	D3535	SHEET 3 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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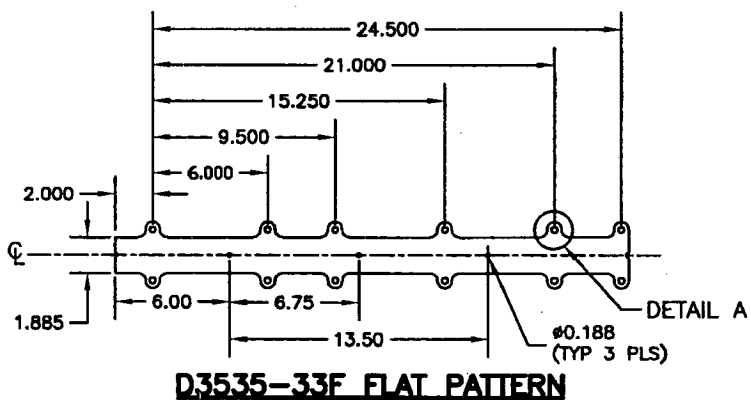
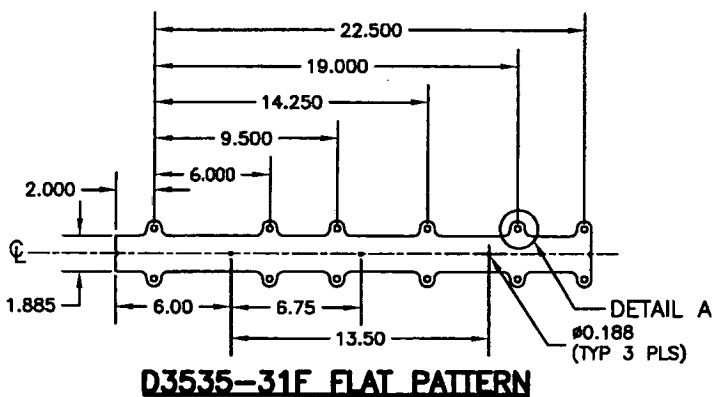
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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NOTES

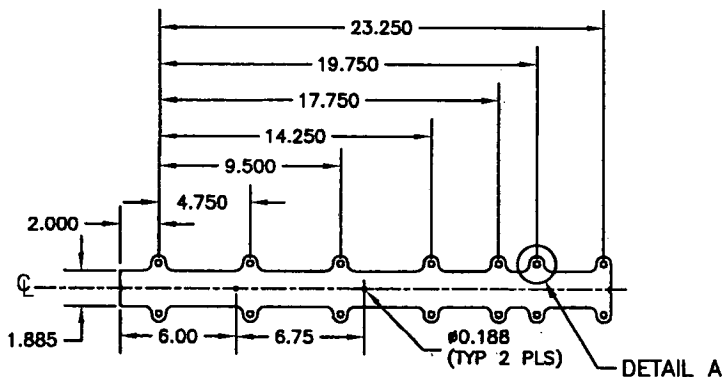
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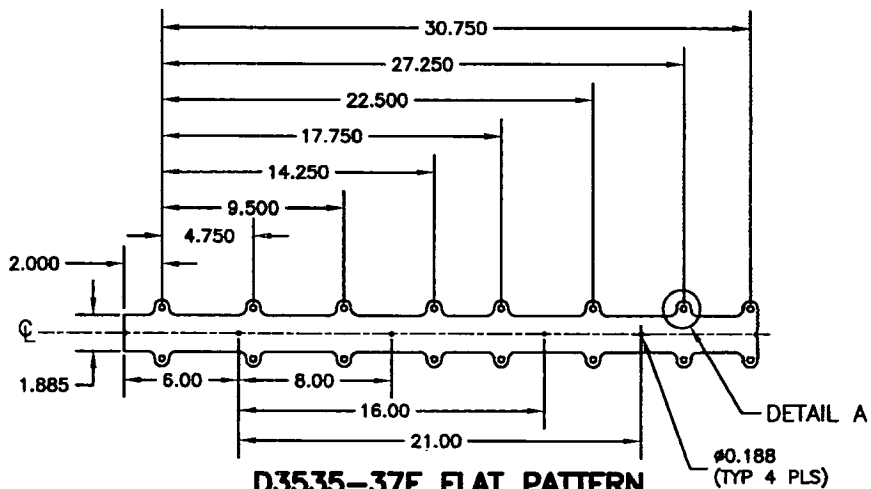
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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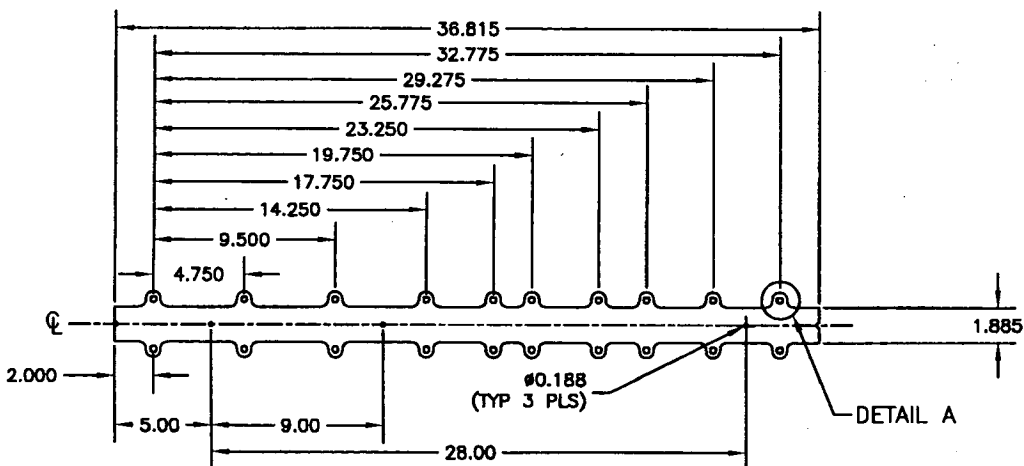
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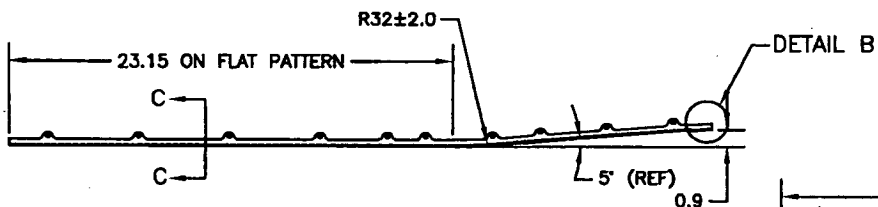
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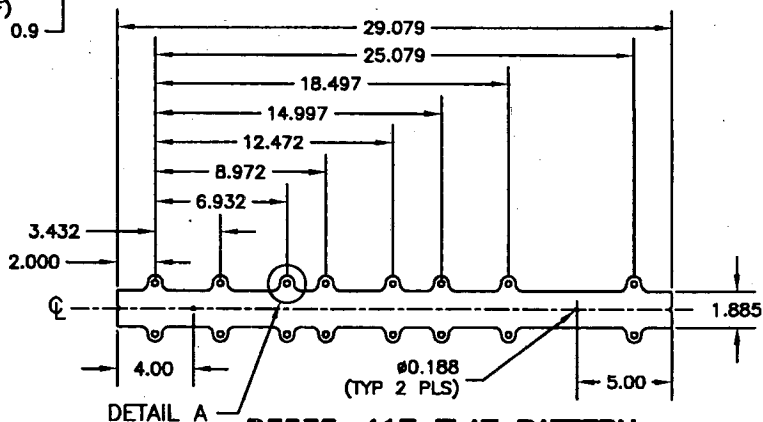
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



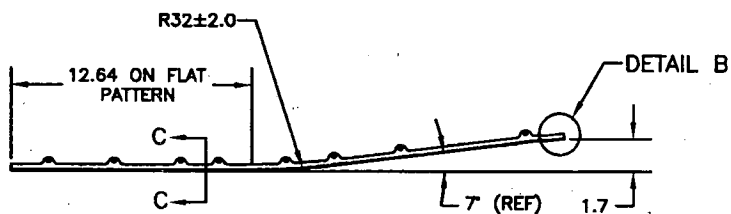
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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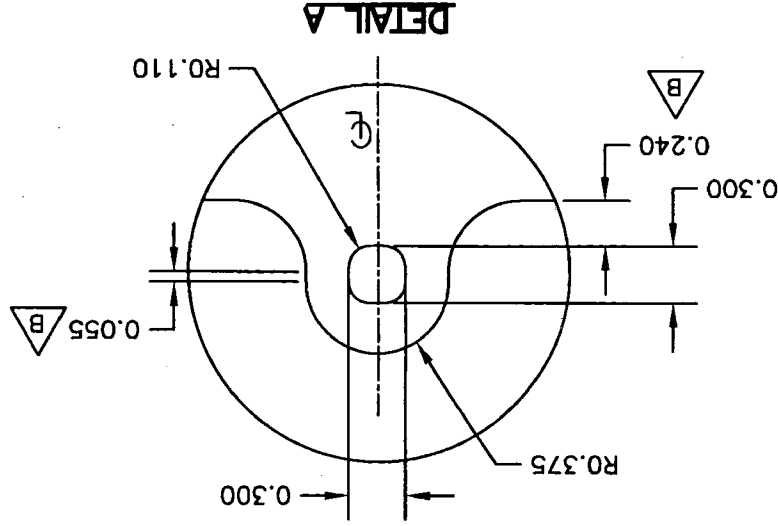
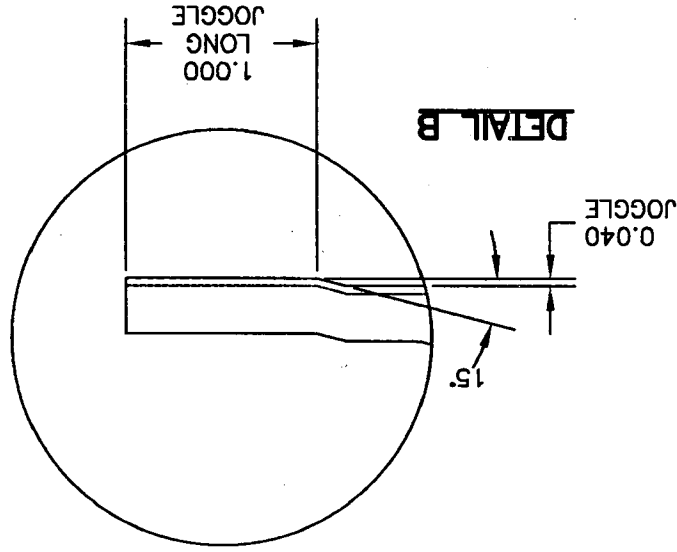
WORK
3/24/10

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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1	

SWAP

07.01.24



SECTION C-C

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
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DART AEROSPACE LTD		Work Order:	33440
Description: WEAR SHOE		Part Number:	D 3535-39
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/- .010	36.815	X			
32.775	+/- .010	32.775	*			
29.275	+/- .010	29.275	*			
25.775	+/- .010	25.775	X			
23.250	+/- .010	23.250	*			
19.750	+/- .010	19.750	*			
17.750	+/- .010	17.750	*			
14.250	+/- .010	14.250	*			
9.500	+/- .010	9.500	*			
4.750	+/- .010	4.750	*			
2.00	+/- .030	2.00	*			
9.00	+/- .030	9.00	*			
1.885	+/- .010	1.888	X			
28.00	+/- .030	28.00	Y			
Ø .188	+ .005 - .001	.190	X			
Ø 300X300	+ .006 - .001	.304X304	Y			

Measured by: HB	Audited by: 	Prototype Approval:
Date: 07-07-21	Date: 07/07/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

